Item ID:	D2348	Accept	***N9000401NN*** Setup Start ***NS1***
Revision ID:			Stop ***NS2***
Item Name:	Wearplate		
Start Date:	1/21/13 **Start Qty:** 24.00	***24***	**Cust Item ID:**
Required Date:	2/08/13 **Req'd Qty:** 24.00	***24***	**Customer:**
Reference:			

Approvals: **Process Plan:** _MLJ_ **Date:** _13-01-24_ **Tooling:** _____ **Date:** _____   Run Start ***NR1***

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____   Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D2348	Rev C								
100 ***100*** Waterjet FLOW CNC Waterjet	FLOW WATER JET **Memo** 1-Cut as per Dwg D2348 Dwg Rev: C Prog Rev: C 2-Deburr if necessary	0.00 0.00 0.00				24			DAS 05 9-89 13·03·06
110 ***110*** QC Quality Control	QC2- Inspect parts off machine FAI/FAIB **Memo**	0.00 0.00				24			DAS 05 9-89 13·03·06
120 ***120*** QC Quality Control	QC8- Inspect parts - second check **Memo**	0.00 0.00				(24)	13·03·06		DAS 09 9-89

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS				

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐   Crosstube ☐   Water Jet ☐   Engineering ☐
Machining ☐   Small Fab ☐   Prod. Eng. Coor. ☐   Quality ☐
Thermoforming ☐   Finishing ☐   Rec/Store/Packaging ☐   Other ☐
Large Fab ☐   Composite ☐   Supplier ☐

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric to O/S
☐ Cracks
☐ Crushed/Crimped
☐ Cuffs
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Ripples in Bend
☐ Torque Waves in Extrusion
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damaged
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drill Holes
☐ Drawing
☐ Finish
☐ Folio

☐ Grain
☐ Hardware
☐ Inspection Incomplete
☐ Instructions Incomplete/Unclear
☐ Maintenance
☐ Mislabeled
☐ Misread
☐ Offset
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions

☐ Ovalized
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge

☐ Pressure/Forced
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled

☐ Other
_____
_____
_____

Item ID:	D2348			Accept	*N9000401nn*		Setup	Start	*NS1*
Revision ID:								Stop	*NS2*
Item Name:	Wearplate								
Start Date:	1/21/13	Start Qty:	24.00	*24*		Cust Item ID:			
Required Date:	2/08/13	Req'd Qty:	24.00	*24*		Customer:			
Reference:									

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* Outsource4 Outsource process - Anodize	Outsource process-Anodize per QSI017 4.1.10.1	0.00							
	Memo Issue P/O: 19404 Black Anodize per Dwg D2348 Ensure Certificate of Conformity is attached	0.00					CX 1316 3/22 (24)		
160 *160* Packaging Packaging	Receive & Inspect for Damage & Mat'l Certs	0.00							
	Memo Ensure certificate of conformity is attached	0.00				24x		SP 13-4-02	
170 *170* QC Quality Control	QC5- Inspect part completeness to step on W/O	0.00							
	Memo INSPECT CERTS	0.00				24			

WORK ORDER NON-CONFORMANCE / UPDATE

NCR: Yes / No

Work Order: _____	**DISPOSITION**	**AGAINST DEPARTMENT/PROCESS**

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

Work Order: _____

Part No. _____

NCR No. _____

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio

- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions

- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge

- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled

- ☐ Other

_____
_____
_____

Item ID:	D2348	**Accept**	***N900040100***
Revision ID:			
Item Name:	Wearplate		

Setup Start ***NS1***

Stop ***NS2***

Start Date:	1/21/13	**Start Qty:** 24.00	***24***
Required Date: 2/08/13		**Req'd Qty:** 24.00	***24***
Reference:			

Cust Item ID:

Customer:

Run Start ***NR1***

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 ***180*** Small Fab Small Fab	Small Fab Memo Install Insert as per Dwg D2348	0.00 0.00				24	0		FF 13-04-04
190 ***190*** QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 SMB 0.00 B44				24 coun			
200 ***200*** Packaging Packaging	Identify as per dwg & Stock Location: 8509 Memo	0.00 0.00				24 x			80 13-48

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

	DISPOSITION	AGAINST DEPARTMENT/PROCESS

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐   Crosstube ☐   Water Jet ☐   Engineering ☐
Machining ☐   Small Fab ☐   Prod. Eng. Coor. ☐   Quality ☐
Thermoforming ☐   Finishing ☐   Rec/Store/Packaging ☐   Other ☐
Large Fab ☐   Composite ☐   Supplier ☐   ☐

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric to O/S
☐ Cracks
☐ Crushed/Crimped
☐ Cuffs
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Ripples in Bend
☐ Torque Waves in Extrusion
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damaged
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drill Holes
☐ Drawing
☐ Finish
☐ Folio

☐ Grain
☐ Hardware
☐ Inspection Incomplete
☐ Instructions Incomplete/Unclear
☐ Maintenance
☐ Mislabeled
☐ Misread
☐ Offset
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions

☐ Ovalized
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge

☐ Pressure/Forced
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled

☐ Other
_____
_____
_____

Item ID:	D2348		Accept	***N9000401 00***	Setup	Start	***NS1***
Revision ID:						Stop	***NS2***
Item Name:	Wearplate						

Start Date:	1/21/13	Start Qty: 24.00	***24***	Cust Item ID:
Required Date: 2/08/13		Req'd Qty: 24.00	***24***	Customer:
Reference:				

| Approvals: | Process Plan: _____ | Date: _____ | Tooling: _____ | Date: _____ | Run | Start | ***NR1*** |
| | QC: _____ | Date: _____ | SPC (Y/N): _____ | Date: _____ | | Stop | ***NR2*** |

Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	QC21- Final Inspection - Work Order Release		0.00							
210									13/4/8	
QC	Memo		0.00							
Quality Control										

QCB-04-8

NCR: Yes / No   **WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

	DISPOSITION	AGAINST DEPARTMENT/PROCESS

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION
- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS
- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved									

FAULT CATEGORY

Landing Gear
- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped.
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General
- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio

- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions

- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge

- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other _____
- _____
- _____

Picklist Print

Work Order ID:	96144					
Parent Item:	D2348		Start Date: 1/21/13		Required Date: 2/08/13	
Parent Item Name:	Wearplate		Start Qty: 24.00		Required Qty: 24.00	

Comments:	IPP Rev A	Removed from 9 Digit 05-12-05 JLM
	IPP Rev:B	Now on Waterjet 06-07-03 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3996-FE-832-EF Self-Clinching Fastener		Manufactured	No			180	Each	457.0000	4	96		*FF 13-04-04*	

Location	Loc Qty	Loc Code	
GA *96038*	457		*96*
82502	46		
85727	34		
90233	377		

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063 6061-T6 .063 Sheet		Purchased	No			100	sf	324.0625	0.0198	0.5002104		*13-03-06*	

Location	Loc Qty	Loc Code
MAT021	324.0625	
123135	124.4625	
124003	199.6	

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order: _____	**DISPOSITION**		**AGAINST DEPARTMENT/PROCESS**				
Part No. _____	Rework ☐	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
NCR No. _____	Work Order Update ☐	Large Fab ☐	Composite ☐	Supplier ☐	

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear	**General**			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld
☐ Crushed/Crimped.	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other
☐ Ripples in Bend	☐ Drill Holes	☐ Offset		_____
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration		_____
☐ Turning Sequence	☐ Finish	☐ Out of Sequence		_____
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions		

DART AEROSPACE LTD		Work Order:	96144
Description: Wear Plate		**Part Number:**	**D2348**
Inspection Dwg: D2348 Rev: C			**Page 1 of 1**

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments	
0.250	+/-0.010	0.250	✓		VerN	MM-01	
0.648	+/-0.010	0.648	✓		VerN	,,	,,
0.795	+/-0.005	0.792	✓		VerN	,,	,,
2.046	+/-0.010	2.048	✓		VerN	,,	,,
1.295	+/-0.010	1.295	✓		VerN	,,	,,
Ø0.656	+0.005/-0.000	0.656	✓		VerN	,,	,,
Ø0.290	+0.003/-0.000	0.290	✓		VerN	,,	,,
Ø0.250	+/-0.010	0.250	✓		VerN	,,	,,
0.250	+/-0.010	0.250	✓		VerN	,,	,,
0.648	+/-0.010	0.648	✓		VerN	,,	,,
1.546	+/-0.005	1.546	✓		VerN	,,	,,

Measured by:	(signature)	Audited by:	DAB 09 9-89	Preliminary Approval:	
Date:	13.03.06	**Date:**	13.03.06	**Date:**	

Rev	Date	Change		Revised by	Approved
A	04.06.25	New Issue	P/O D350-616-015	KJ/JLM	(signature)
B	10.06.04	Dimensions update per Dwg Rev C		KJ	(signature)

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D2348	WEAR PLATE
2	1	D2348F	FLAT PATTERN
3	4	D3996-FE-832-EF	SELF-CLINCHING FASTENER

D3996-FE-832-EF
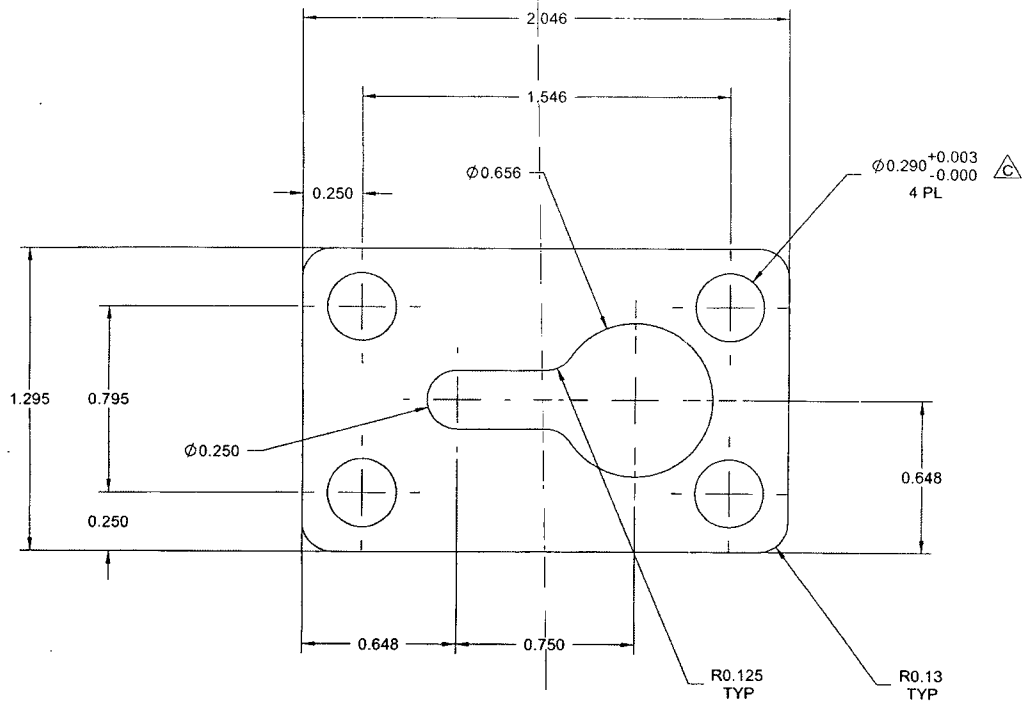SELF-CLINCHING FASTENER
4 PL

D2348F
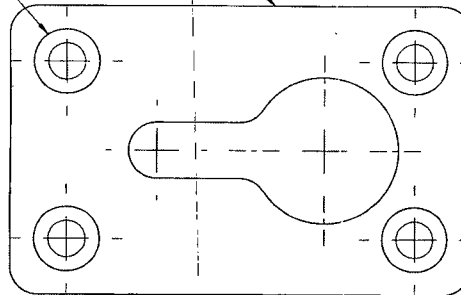
D2348 WEAR PLATE
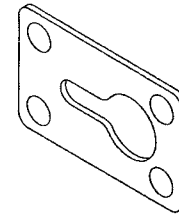
9614 3/4 MLS
13-01-24

RELEASED
2009-11-09

C	REDRAW, ADD +0.003/-0.000 TOL (ZN D4-2), NCR 08-042	CP	09.10.01
B2	CHANGED BACK TO 6061-T6	DS	02.02.21
B1	CHANGED TO AISI 304/316 MATERIAL	DS	00.03.07
B	CHANGED PEM INSERT TO 8-32	BW	95.02.20
REV.	DESCRIPTION	BY	DATE

DESIGN	BW	**DART AEROSPACE LTD**	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D2348	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		WEAR PLATE	NTS
DATE	09.10.01		

NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2348" USING REMOVABLE TAG
7) WEIGHT: 0.01 lbs

96144

2.046

1.546

0.250

ϕ0.656

ϕ0.290 +0.003 / -0.000 /C\
4 PL

1.295 0.795

ϕ0.250

0.648

0.250

0.648   0.750

R0.125
TYP

R0.13
TYP

D2348F FLAT PATTERN

RELEASED
2009 -11- 0.8

NOTES:
1) MATERIAL: 6061-T6 ALUMINUM SHEET 0.063 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
    REF DART SPEC M6061T6S.063
2) FINISH: BLACK ANODIZE PER MIL-A-8625F TYPE I/IB/IC/II/IIB CLASS 2
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2348F" USING REMOVABLE TAG
7) WEIGHT: 0.01 lbs

ATG INDUSTRIES INC.

A.T.G. Industries Inc.
731, rue Industrielle Rd.
PLATING DEPARTMENT
Rockland, On K4K 1T2
Canada
Ph: (613) 446-4544
Fax: (613) 446-4556

Pack List

Number: 62282   Date: 26-Mar-13

To	Ship To
DART AEROSPACE LTD 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 Canada	DART AEROSPACE LTD 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 Canada
Ph: 613-632-5200 Fax: 613-632-1185	Ph: 613-632-5200 Fax: 613-632-1185

Terms	Ship Via

Quantity	Description
1 lot	Part: ASST Rev: 3 PCS 647.7918 3 PCS 647.1814 3 PCS 647.7917 4 PCS 41232-200-002-001 HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2 24 PCS D2348 20 PCS D2428 8 PCS D4726-1 20 PCS D2056 BLACK ANODIZE MIL-A-8625 TYPE II CLASS 2 8 PCS D3299-7 BLUE ANODIZE MIL-A-8625 TYPE II CLASS 2 Job: 20130177 PO: 19404 Line:

Certificate of Conformance

A.T.G. Industries certifies that all items in this shipment are in conformance
with all requirements, specifications and drawings referenced in the purchase order.

ISO 9001 : 2008 REGISTERED
ATG SALES-2010 TERMS APPLY

DATE : 26/3/13

CERTIFIED SIGNATURE : _____

RECEIVER SIGNATURE : _____